

Date: Thursday, 12/06/2008 3:46:54 PM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LATCH BRACKET  
 Job Number : 39849  
 Estimate Number : 10994  
 P.O. Number :  
 This Issue : 12/06/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D2583  
 First Issue : / / Type : SMALL / MED FAB Drawing Number : D2583 REV. B  
 Previous Run : 38032 Project Number : N/A  
 Material : B  
 Due Date : 30/06/2008 Qty: 20 Um: Each  
 Written By :  
 Checked & Approved By : Julie Lecocq  
 Comment : Est: C 00.11.01 Removed P/O for Powder Coat- in house  
 processDM  
 Est: D 06.07.21 Waterjet EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M5052H32S040 5052-H32 .040 Sheet



Comment: Qty.: 0.1227 sf(s)/Unit Total : 2.4549 sf(s)

Material: 5052-H32 (QQ-A-250/8) 0.040" thick  
 (M5052H32S040)

Batch: 106 900 IB 8-6-16

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2583

Dwg Rev: B

Prog Rev: B

IB 8-6-16

(32)

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



IB 8-6-16

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

8 08/06/19 (32) counter

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr

Form on CNC Brake as per Dwg D2583

8 08/06/16 (32)

8 08/06/19 (32)

(32)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/06/2008 3:46:54 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH BRACKET

Job Number: 39849

Part Number: D2583

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*center*  
*S 08/06/19* (X32)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*M- 08/06/19*

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

*10:35*

OVEN TEMPERATURE:

*320°*

FINISH TIME:

*11:05*

*FL 08/06/23*

(32)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*M- 08/06/24*

(32X)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*ST 222*

*SS 08/06/25* (X32)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/06/25*

Job Completion



*MF 08-06-25*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

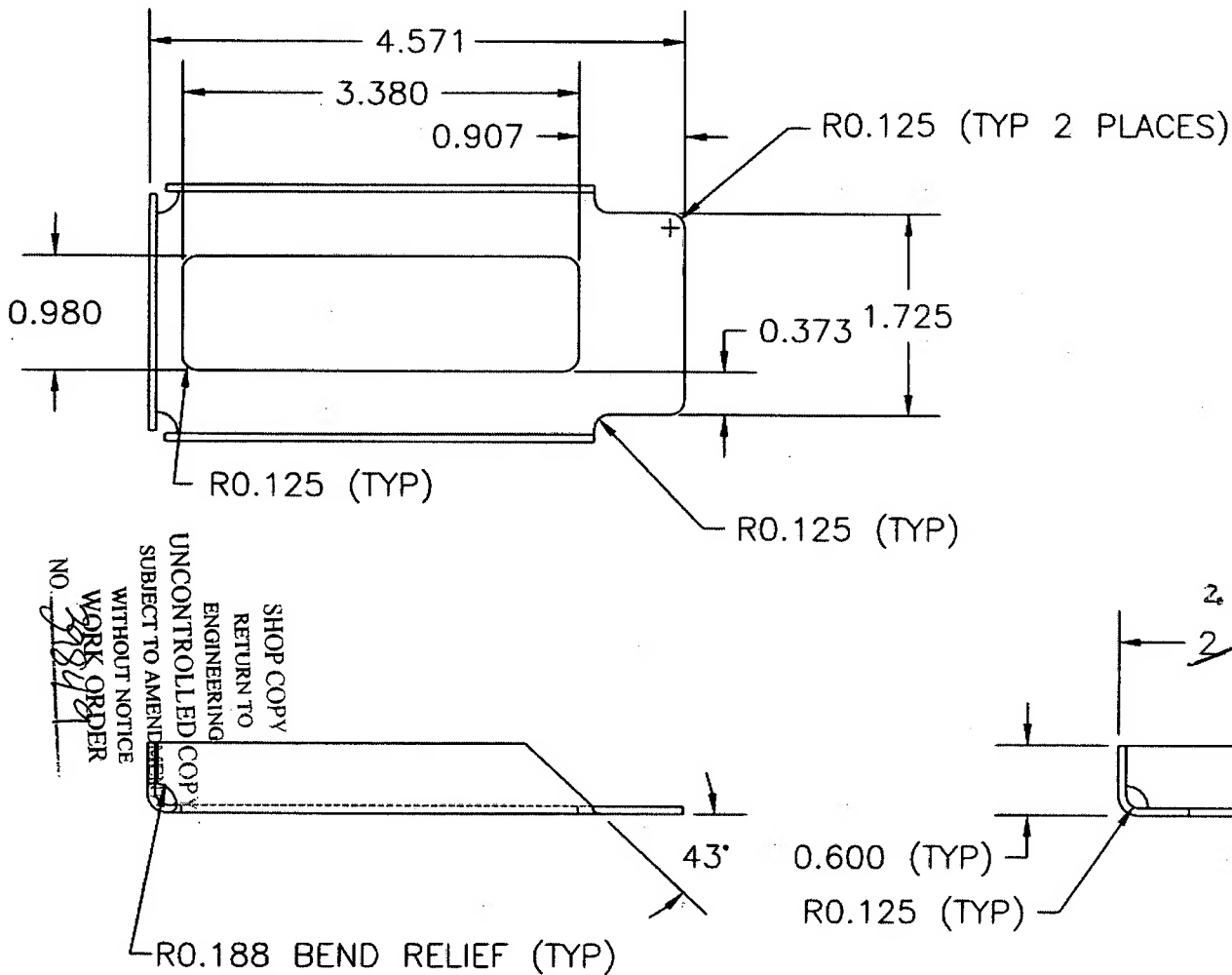
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**DART****RELEASED**  
KE 99.02.25

DESIGN	MIKE M.	DRAWN BY	RF	DART AEROSPACE LTD
CHECKED	CP	APPROVED	KE	HAWKESBURY, ONTARIO, CANADA
DATE	99.02.22	DRAWING NO.	D2583	REV. B
		TITLE	LATCH BRACKET	SHEET 1 OF 1
				SCALE
A	96.07.10	NEW ISSUE		2:3
B	99.02.22	CHANGE OF FINISH (PER TSR A887)		



MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
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WITHOUT NOTICE  
WORK ORDER  
NO. 2884